

Work Order ID 111265

January-09-14 1:47:29 PM

111265

PKg as only
041 Page 1

Item ID: D350-689-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Dual High Back Seat Assembly

Start Date: 1/09/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/09/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3022	B								
D3023	A								
IIN D350-689	B								

100

0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefiles and create labels as per PPP D350-689-041 CHG002

105

0.00

105

Brake NC

Large Fab

Memo

0.00

Brake NC

1-Bend D3023-1 form edge of back pan as per dwg D3023 using D3017-041 back frame
2- Bend D3022-1 as per dwg

1 BL 141-8

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111265

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Item ID: D350-689-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Dual High Back Seat Assembly

Start Date: 1/09/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/09/14 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

118

0.00

118

Small Fab

Memo

0.00

Small Fab

Assemble back panel to back frame as per dwg

1X

14/01/09

119

QC5- Inspect part completeness to step on W/O

0.00

119

QC

Memo

0.00

Quality Control

DAS
27
9-89

14/11/10

1

120

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

120

Powdercoat

Memo

0.00

Powder Coating

Powder coat

14123020

START TIME:

9:30

OVEN TEMPERATURE:

320°K

FINISH TIME:

10:00

14/01/10

DAS
36
9-89

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Item ID: D350-689-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Dual High Back Seat Assembly

Start Date: 1/09/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/09/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: _____

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

14/1/10
DAS
6
8-89

PL 14-01-13

MF
14-01-10

Picklist Print

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Page 1

Work Order ID: 111265

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 1/09/14

Required Date: 1/09/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H Removed Sub-Parts 06-02-09 JLM
IPP Rev:I As per NCR 070 06-09-06 JLM
10.02.12 verified by:JLM
IPP Rev:J as per DSI 9498 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-12A Bolt		Purchased	No			140	Each	93.0000	3	3		DAS 32 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		3							
				m126192		3							
				ST511		90							
				m125709		90							
D3016-041 Seat Frame Assembly		Manufactured	No			114	Each	0.0000	1	1		EL 14-1-8	
D3017-041 Seat Back		Manufactured	No			114	Each	0.0000	1	1		EL 14-1-8	
D3021-041 Tube Assembly		Manufactured	No			140	Each	0.0000	1	1		EL 14-1-8	
D3022-1 Seat Pan		Manufactured	No			100	Each	1.0000	1	1		EL 14-1-8	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA001		1							
				108108		1							
D3023-1 Back Panel		Manufactured	No			100	Each	1.0000	1	1		EL 14-1-8	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA001		1							
				107557		1							
D3024-1 Spacer		Manufactured	No			140	Each	32.0000	3	3		DAS 32 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST023		32							
				104966		8							
				109093		24							

M/26/92

EL 14-1-8

EL 14-1-8

EL 14-1-8

EL 14-1-8

EL 14-1-8

1

104966

14/01/9

Picklist Print

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Page 2

Work Order ID: 111265

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 1/09/14

Required Date: 1/09/14

Start Qty: 1.00

Required Qty: 1.00

D3028-1	Manufactured	No	140	Each	30.0000	4	4	✓	DAS 32 9-89
Stud									
			<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>
			ST023		30				
			106728		20				
			97695		10				
D3029-1	Manufactured	No	140	Each	10.0000	2	2	✓	DAS 36 9-89
Spring									
			<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>
			GA		10				
			105583		10				
D3030-1	Manufactured	No	140	Each	4.0000	2	2	✓	DAS 32 9-89
Lock									
			<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>
			ST023		4				
			97713		4				
D3031-1	Manufactured	No	140	Each	15.0000	2	2	✓	DAS 32 9-89
Loop									
			<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>
			GA		1				
			79747		1				
			ST024		14				
			109419		8				
			97679		6				
MS20600-AD4W2	Purchased	No		Each	1,819.0000				DAS 32 9-89
Rivet									
			<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>
			ST311		600				
			m125708		600				
			ST506		319				
			125578		319				
			ST554		900				
			m126475		900				

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 111265

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 1/09/14

Required Date: 1/09/14

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

Each 949.0000

6

DAS

32

9-89

Cherry Rivets

Location

Loc Qty

Loc Code

ST311

580

122151

100

m127476

480

WA003

369

107939

369

M127476

MS21042L3

Purchased

No

140 Each 6,010.0000

17

17

DAS

32

9-89

Nut

Location

Loc Qty

Loc Code

ST506

962

123900

962

ST509

5000

M127304

1000

M127410

3000

M127831

1000

ST510a

48

M126333

48

M126333

DAS

32

9-89

MS21042L4

Purchased

No

140 Each 5,355.0000

6

6

Locknut

Location

Loc Qty

Loc Code

GA

80

m126333

80

ST509

4000

m127255

2000

m127813

2000

ST518

1275

m127376

1275

m127376

Picklist Print

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Work Order ID: 111265

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 1/09/14

Required Date: 1/09/14

Start Qty: 1.00

Required Qty: 1.00

MS24693-S272
SCREW

Purchased

No

140

Each

389.0000

4

4

DAS
DAS
32
9-89

Location

Loc Qty

Loc Code

GA

318

M126190

318

ST301

71

M126119

71

M126119

MS27039-1-17

Purchased

No

140

Each

476.0000

4

4

DAS
32
9-89

Screw (601.1954)

Location

Loc Qty

Loc Code

GA

54

120142

54

ST306

272

124326

122

m127305

150

ST506

150

m127831

150

124326

MS27039-1-19

Purchased

No

140

Each

200.0000

6

6

DAS
32
9-89

Screw

Location

Loc Qty

Loc Code

ST506

200

124326

50

125654

150

128604

MS27039-4-21

Purchased

No

140

Each

38.0000

6

6

DAS
32
9-89

Screw

Location

Loc Qty

Loc Code

ST307

38

m126319

13

m127813

25

124326 126319

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Shop Packet Print

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Picklist Print

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Work Order ID: 111265
 Parent Item: D350-689-041
 Parent Item Name: Dual High Back Seat Assembly

Start Date: 1/09/14 Required Date: 1/09/14
 Start Qty: 1.00 Required Qty: 1.00

NAS1149D0332J Purchased No 140 Each 2,010.0000 17 17 9-89 32 DAS 9-89
 Washer

Location	Loc Qty	Loc Code
ST293	610	
m127431	610	
ST294	10	
m125807	10	
ST510a	1390	
m127374	390	
m127389	1000	

m127431

NAS1149D0432J Purchased No 140 Each 384.0000 6 6 9-89 32 DAS 9-89
 WASHER

Location	Loc Qty	Loc Code
GA	11	
116583	11	
ST293	30	
124580	30	
ST510a	343	
125578	343	

by 580

13/01/9

R0.38
(TYP)

0.22

JOGGLE ON THIS
SIDE WHERE
SHOWN

RELEASED
9.06.07 #

The drawing consists of two main parts: a bend detail on the left and a flat pattern on the right.

Bend Detail: Shows a 15° bend with a radius of R4.7. The total height of the bend is 22.05. The flat pattern for this bend is shown with dimensions 14.75, 10.92, 7.42, 25.28, 27.03, and 28.10.


Flat Pattern: A large rectangular layout with rounded corners. Key dimensions include:

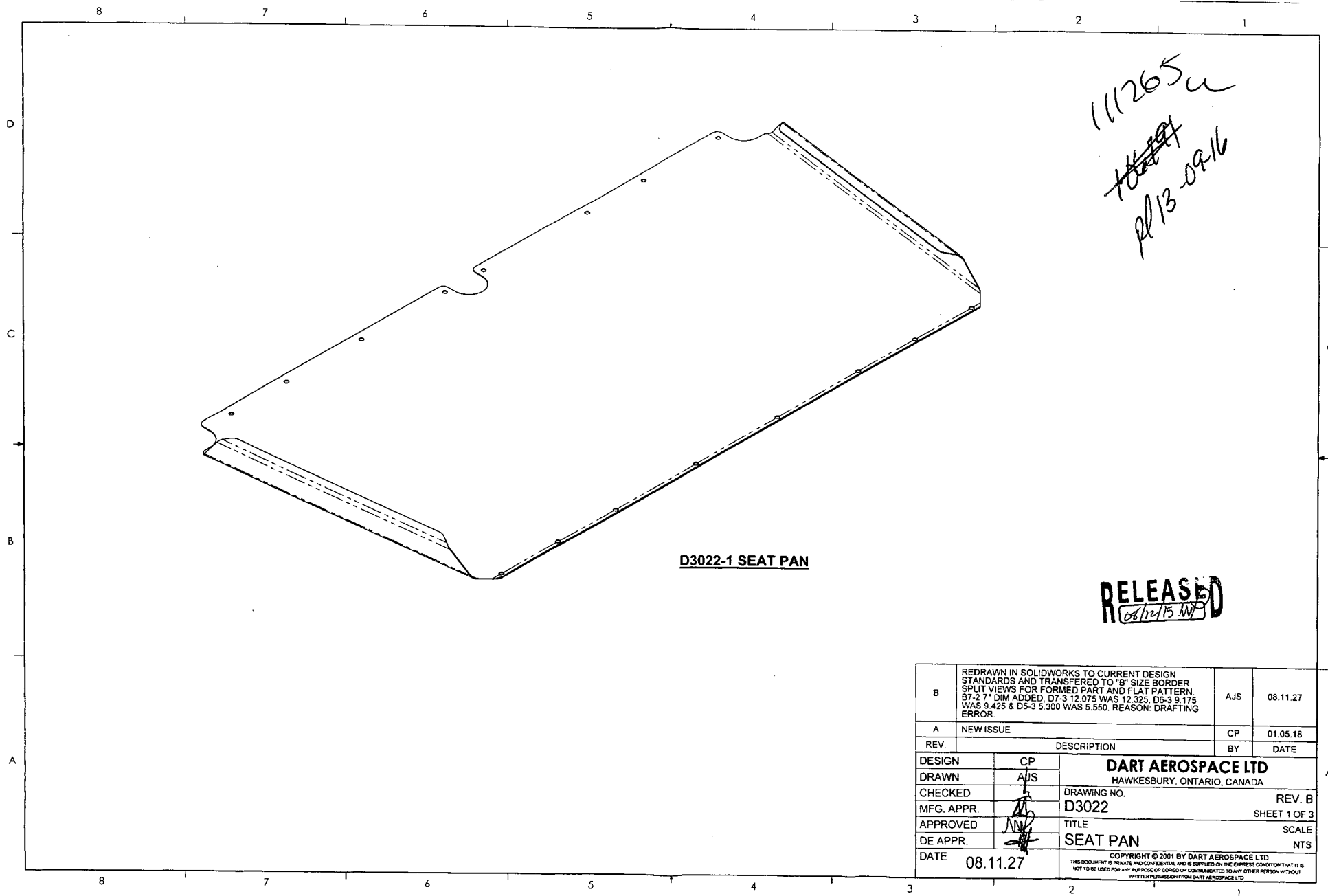
- Top edge: 0.000, 0.375, 1.340, 1.660, 12.76, 8.711, 5.597, 0.000.
- Right edge: 1.970, 8.57, 1.970, 1.970, 1.970.
- Bottom edge: 2.50, 0.62 (TYP).
- Left edge: 2.375 PITCH (TYP), 0.375 (TYP).
- Internal features: Two oval-shaped cutouts with dimensions 10.92, 7.42, and 25.28. A central vertical strip with dimensions 0.50 and 2.50.
- Annotations: "Ø0.191 (TYP 4 PLACES)", "Ø0.128 (TYP 46 PLACES)", "R4.50", "R0.88 (TYP)", "0.049 JOGGLE (SEE SECTION A-A, 3 PLACES)", "2.375 PITCH (TYP)", "11/265", "10/27/16", "R13-0916".

Section A-A: A cross-section view of the duct, showing a semi-circular shape with a radius of R4.50 and a thickness of 0.049. It is labeled "0.049 JOGGLE (SEE SECTION A-A, 3 PLACES)".

Legend: A circular stamp in the top right corner reads "COPY" and "ORIGINAL".

1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANTDEX (REF 4.3.5.6) PER DART QSI 005 4.3
3) ALL DIMENSIONS ARE IN INCHES.
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

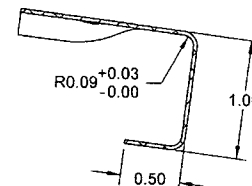
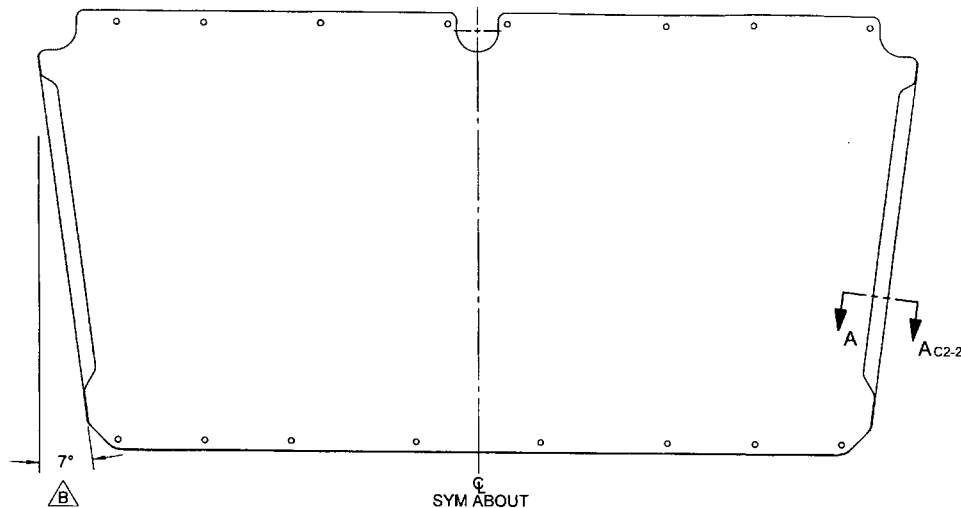
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		CHECKED	<i>A</i>	APPROVED	<i>A</i>	
		DATE		01.05.18		DRAWING NO.
				D3023	SHEET 1 OF	
				TITLE	SCALE	
				BACK PANEL	1:4	



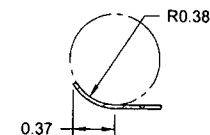
D3022-1 SEAT PAN

RELEASED
08/12/15

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. SPLIT VIEWS FOR FORMED PART AND FLAT PATTERN. B7-2 7" DIM ADDED. D7-3 12.075 WAS 12.325. D8-3 9.175 WAS 9.425 & D5-3 5.300 WAS 5.550. REASON: DRAFTING ERROR.		AJS	08.11.27
A	NEW ISSUE		CP	01.05.18
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3022	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		SEAT PAN	NTS	
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SECTION A-A C4-2
SCALE 4X



SECTION B-B A6-2
SCALE 4X

D3022-1 SEAT PAN

NOTES:

- 1) MATERIAL: MAKE FROM D3022-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3022-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.36 lbs

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED		DRAWING NO. D3022	REV. B
MFG. APPR.		TITLE	SCALE
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DATE	08.11.27		

RELEASED
08/12/15

